

Date: Monday, 12/01/2009 2:36:44 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET
Job Number : 44650	
Estimate Number : 12543	
P.O. Number :	Part Number : D35381
This Issue : 12/01/2009 S.O. No. :	Drawing Number : D3538 REV.A
Prsht Rev. : NC	Project Number : 10254N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 35454	Material :
Written By :	Due Date : 02/02/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 09.01.13</u>	
Comment : Est Rev:A New Issue 06-10.03 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25
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Comment: Qty.: 0.1995 f(s)/Unit Total : 1.9950 f(s)
 6061_T6 Bar 1.250" x 1.250
 Batch: 11/0001

JTP 09/01/17

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 1.500" long

JTP 09/01/17

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: 1-Machine as per Folio FA651 and Dwg D3538

2-Deburr

JTP 09/01/17

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JTP 09/01/17

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

AM 09/01/18

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AM 09.01.19

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:36:45 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 44650

Part Number: D35381

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M109996



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:45am

OVEN TEMPERATURE:

320°F

FINISH TIME:

10:15am

11

09-09-22

X 11

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

A.M

09.01.22

(11)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST108

18

09/01/23

X 11

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26

Job Completion



MF 09-01-23

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>W41050</u>
Description: Hinge Bracket		Part Number: <u>D3538-1</u>
Inspection Dwg: D3538	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

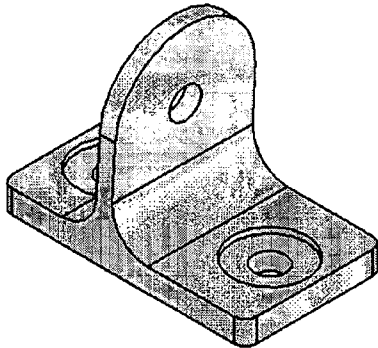
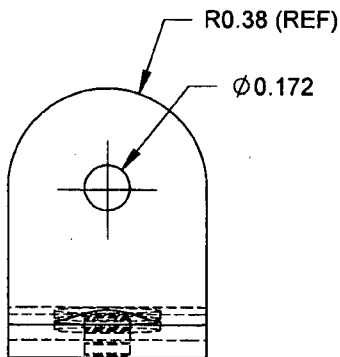
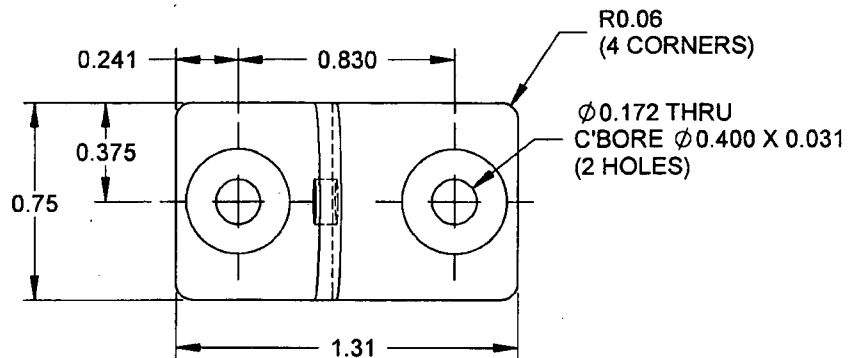
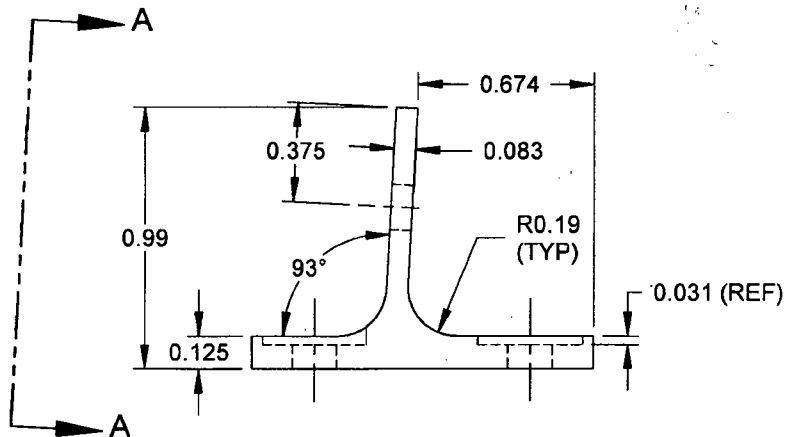
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	0.753	✓			
0.375	+/-0.010	0.375	✓			
0.241	+/-0.010	0.244	✓			
0.830	+/-0.010	0.825	✓			
Ø0.172	+0.005/-0.001	0.174	✓			
Ø0.400	+0.006/-0.001	0.400	✓			
0.031	+/-0.010	0.031	✓			
1.31	+/-0.030	1.315	✓			
0.375	+/-0.010	0.375	✓			
0.99	+/-0.030	0.993	✓			
0.125	+/-0.010	0.130	✓			
R0.19	+/-0.030	0.187	✓			
0.083	+/-0.010	0.084	✓			
93°	+/-0.5°	93°	✓			
0.674	+/-0.010	0.679	✓			
R0.38	+/-0.030	0.380	✓			
Ø0.172	+0.005/-0.001	0.173	✓			

Measured by: <u>DJP</u>	Audited by: <u>ml</u>	Prototype Approval:	N/A
Date: <u>09/01/17</u>	Date: <u>09/01/18</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	<u>[Signature]</u>

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3538	REV. A SHEET 1 OF 2
DATE 06.10.13	TITLE HINGE BRACKET		SCALE 1:1
REV A	DATE 06.10.13	DESCRIPTION NEW ISSUE	

**RELEASED**
06.10.13**AUXILIARY VIEW A****D3538-1 HINGE BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

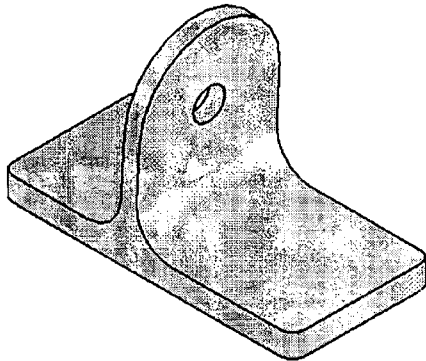
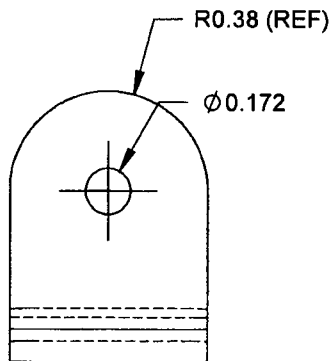
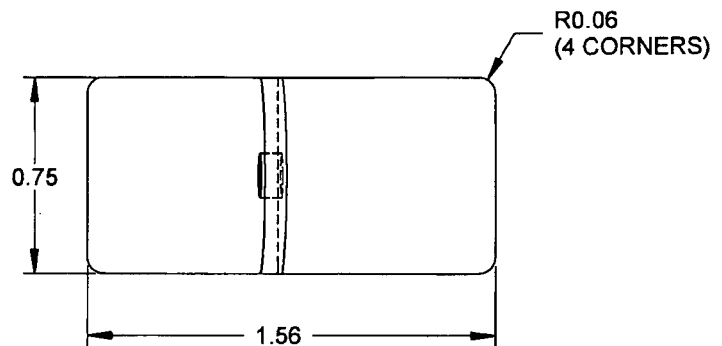
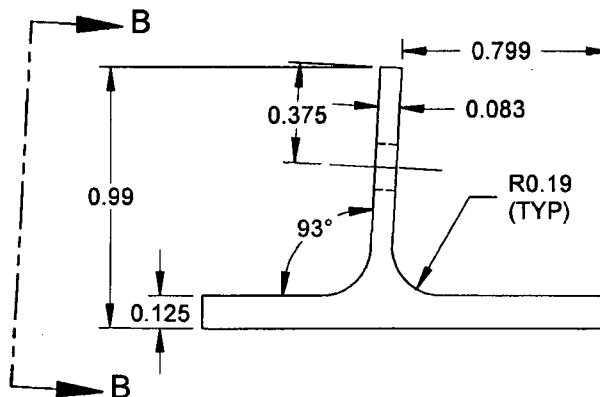
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NO. *44650*

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DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3538	REV. A SHEET 2 OF 2
DATE 06.10.13		TITLE HINGE BRACKET	SCALE 1:1

**RELEASED**
06.10.13**AUXILIARY VIEW B****D3538-3 HINGE BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

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